

Work Order ID 85000

May-31-12 8:56:51 AM

85000

Page 1

Item ID: D412-698-027 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly, LH (Aluminum Doors)
 Start Date: 5/31/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/31/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9484	C								
100		0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D412-698-027/ DSI9484 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

① w/ 12.05.31
 MJS 12/05/31

12/5/31

1 w/ 12.05.31

Work Order ID 85000***85000***

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Item ID: D412-698-027

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly, LH (Aluminum Doors)

Start Date: 5/31/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/31/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-027/ DSI 9484

Location: _____

PPP rev: _____

12/31/12

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ 12/05/13

MCJ 12/05/13

Picklist Print

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Page 1

Work Order ID: 85000

Parent Item: D412-698-027

Start Date: 5/31/12

Required Date: 5/31/12

Parent Item Name: Bracket Assembly, LH (Aluminum Doors)

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
ECN11-531 verified by:EC

IPP Rev:B 11.03.31 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3199-3 Bracket, Fwd LH		Manufactured	No			110	Each	30.0000	1	12/15/31			

Location

Loc Qty

Loc Code

ST236B

30

75206

13

77361

17

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION
AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43

REF. FAA STC: SR01446NY

REF. EASA.IM.R.S.00709

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits and forward D3675-1 brackets that are part of the D412-698-031/-032/-033 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kits that includes a longer D3199-3/-4 bracket for installation in the first forward position of the D412-698-011/-012/-017 kits to reduce wear on these forward brackets on aircraft equipped with aluminum doors. Likewise, Dart has developed the D412-698-037/-038 kits that includes a longer D3675-5/-6 bracket for installation in the first forward position of the D412-698-031/-032/-033 kits to reduce wear on these forward brackets on aircraft equipped with composite doors.

The D412-698-027/-028/-037/-038 kits may be installed as follows:

- 1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698
- 2) Remove the first forward D3199-1 or D3675-1 brackets as applicable.
- 3) Install the D3199-3/-4 or D3675-5/-6 bracket as applicable in lieu of the removed -1 bracket. Refer to Figure 1 Sheet 2 (aluminum doors) or Figure 2 Sheet 3 (composite doors).
- 4) Torque hardware per ICA-D412-698.
- 5) Re-install sliding door on aircraft per Section 52.2/52.3 of ICA-D412-698 as applicable.
- 6) Make entry in technical records of aircraft indicating that DSI 9484 has been completed.

PARTS LIST

QTY. -027	QTY. -028	QTY. -037	QTY. -038	PART NUMBER	DESCRIPTION
X				D412-698-027	BRACKET KIT, LH (ALUMINUM DOORS)
	X			D412-698-028	BRACKET KIT, RH (ALUMINUM DOORS)
		X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
			X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
1				D3199-3	FORWARD BRACKET, LH
	1			D3199-4	FORWARD BRACKET, RH
		1		D3675-5	FORWARD BRACKET, LH
			1	D3675-6	FORWARD BRACKET, RH

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal		Applicability
		Arm	Moment	Arm	Moment	
D412-698-027 Bracket Kit	0.16 lb 0.07 kg	-48.0 in -1.22 m	-7.68 in-lb -0.09 m-kG	102.3 in 2.60 m	16.37 in-lb 0.18 m-kG	Aircraft Equipped with P/N 205-032-669-XXX Aluminum Doors
D412-698-028 Bracket Kit	0.16 lbs 0.07 kg	+48.0 +1.22 m	+7.68 in-lb +0.09 m-kG	102.3 in 2.60 m	16.37 in-lb 0.18 m-kG	
D412-698-037 Bracket Kit	0.18 lb 0.08 kg	-48.0 in -1.22 m	-8.64 in-lb -0.10 m-kG	102.3 in 2.60 m	18.41 in-lb 0.21 m-kG	Aircraft Equipped with P/N 412-030-300-XXX Composite Doors
D412-698-038 Bracket Kit	0.18 lb 0.08 kg	+48.0 in +1.22 m	+8.64 in-lb +0.10 m-kG	102.3 in 2.60 m	18.41 in-lb 0.21 m-kG	

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE #02)

DATE: 11.03.21
CERT. NO.: SH92-43
ISSUE NO.: 5

C	UPDATED -027/-028/-037/-038 KITS AND INSTALLATION	MB	11.03.21
B	ADDED -037/-038 KIT FOR COMPOSITE DOORS; UPDATED TITLE ACCORDINGLY.	MB	10.12.17
A	NEW ISSUE	<u>MB</u>	09.10.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>MB</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>MB</u>		
CHECKED	<u>ASS</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>N/A</u>	DSI 9484	SHEET 1 OF 3
APPROVED	<u>MB</u>	TITLE	SCALE
DE APPR.	<u>MB</u>	D412-698-027/-028/-037/-038 Kits	NTS
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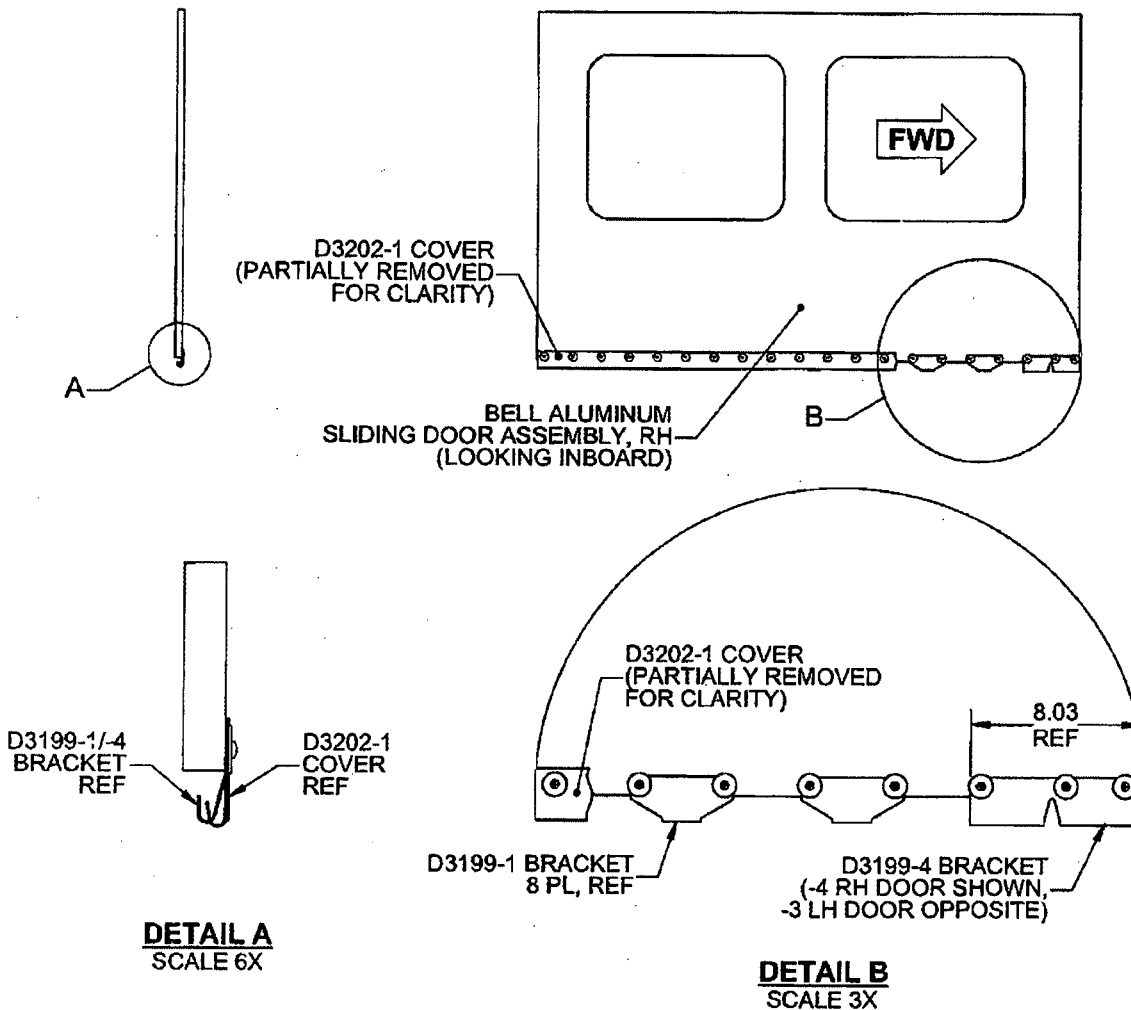






FIGURE 1: D3199-3/-4 BRACKET INSTALLATION ON ALUMINUM DOORS
(-4 SHOWN, -3 OPPOSITE)

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.03.21
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MFG. APPR.	N/A	DSI 9484	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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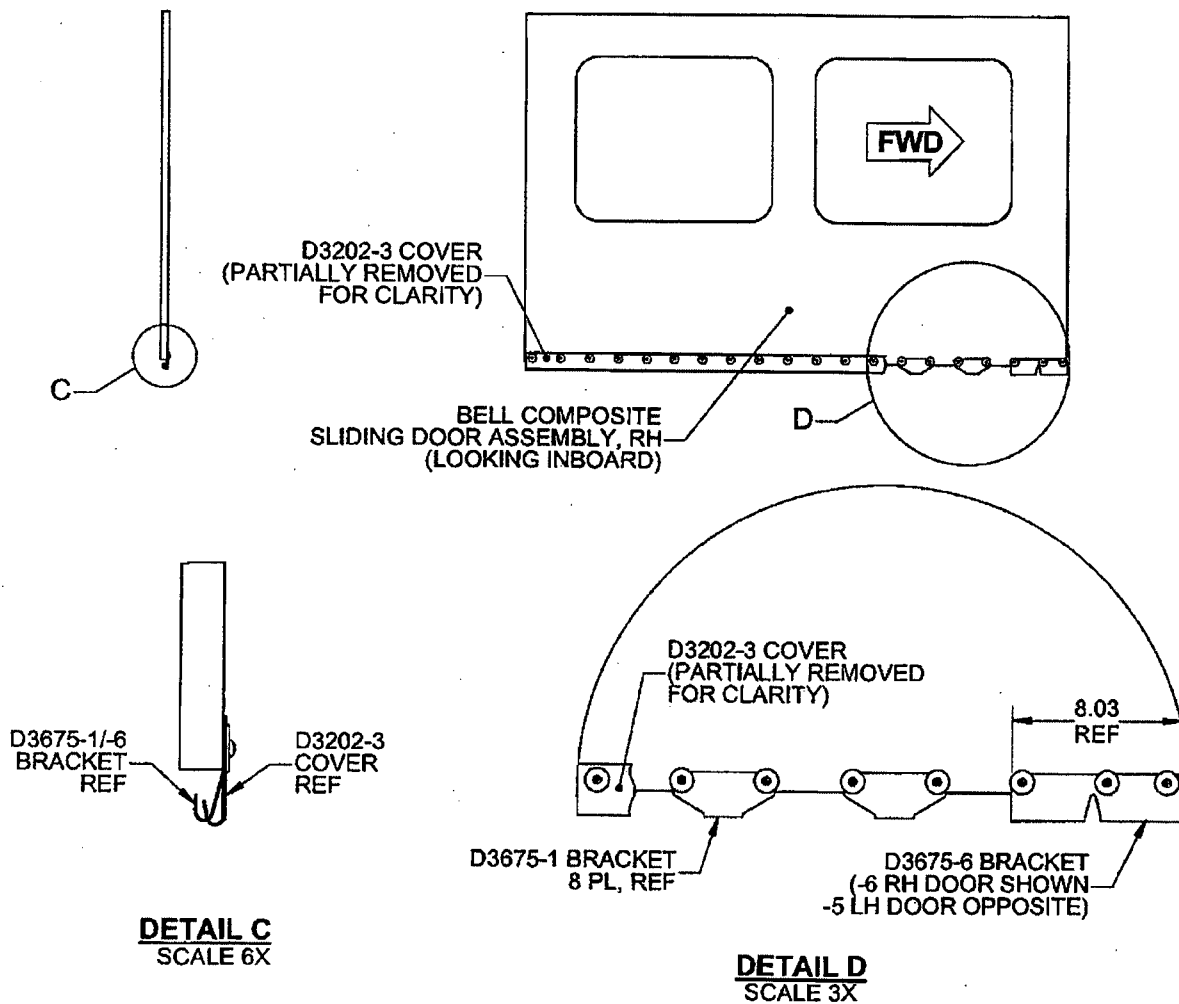






FIGURE 2: D3675-5/-6 BRACKET INSTALLATION ON COMPOSITE DOORS
(-6 SHOWN, -5 OPPOSITE)

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BY: *[Signature]*
D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9484	SHEET 3 OF 3
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